

# Work Order ID 76376

**\*76376\***

Page 1

November-11-11 9:17:24 AM

Item ID: D2572 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Fwd In 205  
 Start Date: 11/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 18/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: M.L. J Date: 11/11/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								

100 0.00  
**\*100\*** HAAS CNC VERTICAL MACHINING #1  
 HAAS I Memo 0.00 amt 11/11/15 6 0  
 HAAS CNC vertical machine #1 Program Batch No. 76376  
 Double check by: SE  
 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension  
 Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension  
 Sheets  
 3-Machine Step No 3 per Folio FA051 and insp

110 0.00  
**\*110\*** CONVENTIONAL MILLING MACHINE  
 Mill Conv Memo 0.00 amt 11/11/12 6 0  
 Conventional Milling Machine Machine keyway as per dwg D2571 & D2572

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76376

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Page 2

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Item ID: D2572 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
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 Start Date: 11/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 18/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		<i>amk 11/11/15</i>		<u>6</u>	<u>0</u>		
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		<i>SL 11-11-23</i>		<u>6</u>			
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				<u>6</u>	<u>17-11-23</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76376

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Page 3

November-11-11 9:17:24 AM

Item ID: D2572 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, Fwd In 205  
Start Date: 11/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 18/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Powdercoat Powder Coating W118434	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 10:15 OVEN TEMPERATURE: 320 OF FINISH TIME: 10:45	0.00							6x0 m/11/11/23
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00							6 BR 11-11-23
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location: 433  Memo	0.00							Setup 3 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76376

**\*76376\***

Page 4

November-11-11 9:17:24 AM

Item ID: D2572

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Fwd In 205

Start Date: 11/11/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 18/11/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:


Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

u/n/23 



11-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November-11-11 9:17:30 AM

Page 1

Work Order ID: 76376

**\*76376\***

Parent Item: D2572

**\*D2572\***

Parent Item Name: Saddle, Fwd In 205

Start Date: 11/11/2011

Required Date: 18/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	67.0000	1	6			

**\*D6101-005\***

**\*\***

Saddle Billet

Location	Loc Qty	Loc Code
MAT	8	
71721	8	
MAT045	48	
73420	40	
74507	8	
MAT046	11	
66966	3	
74507	8	

*6* *confidential*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 76376
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.259	.259	.259	.289		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.577		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.131	.132	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.239		
W	0.115	0.135		.130	.131	.133	.133		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.762	.763	.763	.764		
Z	0.352	0.372		.365	.365	.366	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.624	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.248	.247		
AE	1.375	1.395		1.586	1.5855	1.586	1.586		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.249	.250	.249		
AI	2.000	2.020		2.003	2.002	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>omk</i>
Date: 11/11/15

Audited by: <i>SL</i>
Date: 11-11-23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76376
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

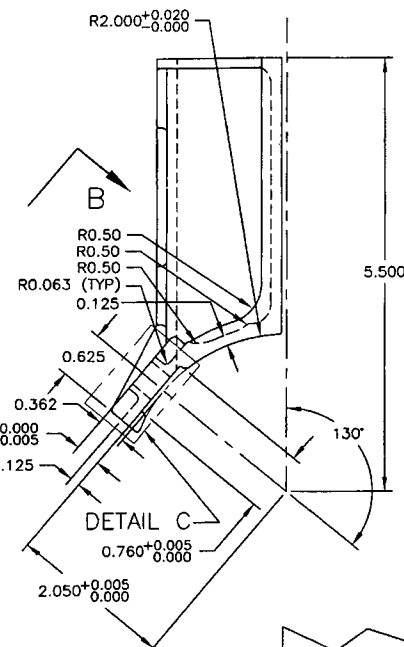
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	76	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
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F	0.490	0.510		.502	.500				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.506	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.126	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.250				
S	0.115	0.135		.120	.120				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.240	.240				
W	0.115	0.135		.133	.133				
X	0.307	0.312		.312	.312				
Y	0.760	0.765		.764	.764				
Z	0.352	0.372		.366	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.624	.624				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.246	.249				
AE	1.375	1.395		1.3865	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.250	.250				
AI	2.000	2.020		2.004	2.002				
AJ	0.023	0.043		.032	.032	.033			
Accept/Reject									

Measured by: <i>amp</i>
Date: 11/11/18






Audited by: <i>SL</i>
Date: 11-11-23

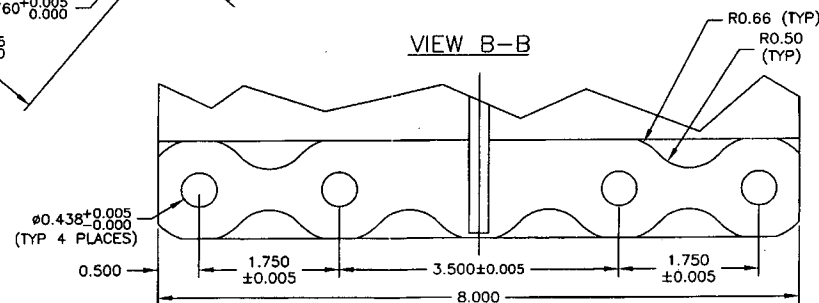
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

05.12.06 ~~11~~






MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010   |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  |
|  | CHAMFER 0.063 x 45° ALL AROUND   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)  |



DETAIL C  
SCALE 2:1

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
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DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN DS		DRAWN BY PH	 <b>DART AEROSPACE LTD.</b> HARRISBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2572	REV. 1 OF 1 SHEET 1 OF 1
DATE 05.07.13		TITLE INNER FWD SADDLE	SCALE 2:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries